

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-027538**Date Inspected:** 04-May-2012**Project Name:** SAS Superstructure**OSM Arrival Time:** 730**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1600**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Pier 7 Job Site**CWI Name:** Salvador Merino**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** S.A.S. Components**Summary of Items Observed:**

The Quality Assurance Inspector (QAI), Scott Croff, was present at the Self Anchored Span (SAS) job site to observe the scheduled fabrication and welding of components for the SFOBB project.

The QAI witnessed work in progress related to Contract Change Order (CCO) 179. The QAI noted that the flux cored arc welding (FCAW) fillet welding is being performed by Jason Collins, ID 8128. At the Handrail Dividers, conduit for lights is being installed through the bikepath segments and being seal welded on the top and bottom surfaces. The QAI noted that the Quality Control Inspector (QCI) Salvador Merino is monitoring this work. The QAI was informed that the welding procedure specification (WPS) being used is ABF-WPS-D11-F2201 and is only fit for purpose of seal welding the conduits. The QAI noted that the WPS is not included in the contractors' Welding Quality Control Plan. A copy of the WPS was made available for reference. The QAI noted that the work was completed on dividers 132 to 139. The QAI also noted that a Request For Information (RFI) to modify the bikepath access gate retainers' weld size from 10mm to 6mm has been approved. Reference RFI-02812R00 for additional information.

The QAI witnessed work in progress in the warehouse at pier 7. The QAI observed welding of dehumidification duct supports onto the SAS main cable saddle shrouds. The QAI noted that an RFI to clarify the welder qualification requirements has been approved and the welding in progress and completed has been conforming to the RFI, as directed by the contractor. The QAI noted that shielded metal arc welding (SMAW) fillet welding of the duct supports is being performed by F.W. Spencer welder Damien Llanos, ID 6845. The QAI noted that the QCI Salvador Merino is monitoring this welding. The QAI noted that the Jacking Saddle Housing cover plates' duct supports have been completed and Magnetic Particle Testing (MT) has been completed and accepted by the

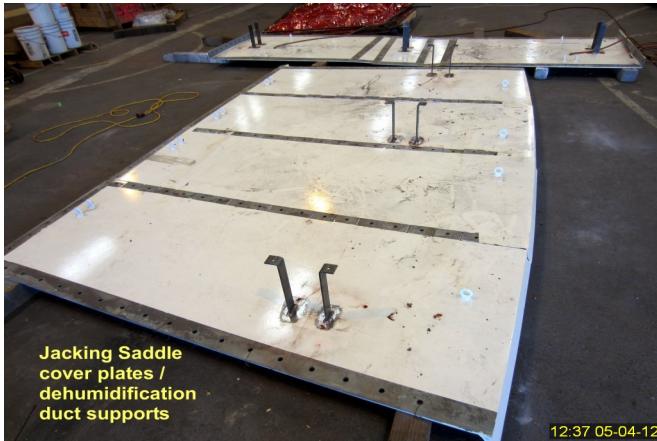
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QCI. The QAI made visual examinations of the welds as they were being prepared for zinc primer. The QAI noted that the welds appeared to be conforming to the AWS D1.1 requirements. See the attached photo.



### Summary of Conversations:

The QAI relayed the status of the CCO 179 work and dehumidification duct support welding to the QAI Lead Bill Levell. Except as described above, there were no other notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy, (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Croff, Scott	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell, Bill	QA Reviewer

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